

Date: Monday, 2/19/2007 3:27:09 PM
User: Kim Johnston

Process Sheet

| | |
|--|--------------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : TAIL LIGHT FAIRING |
| Job Number : 30774 | |
| Estimate Number : 12362 | |
| P.O. Number : | Part Number : D34845 |
| This Issue : 2/19/2007 S.O. No. : | Drawing Number : D3484 REV D |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : 1 / Type : SMALL / MED FAB | Drawing Revision : D |
| Previous Run : 27225 | Material : |
| Written By : | Due Date : 3/10/2007 Qty: 5 Um: Each |
| Checked & Approved By : <u>07.02.19</u> | |
| Comment : Est Rev:A New Issue 06-04-11 JLM | |

Additional Product

Job Number: 

| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|-------------|--------------------|
| 1.0 | M6061T6S050 | 6061-T6 .050 Sheet |
|-----|-------------|--------------------|



Comment: Qty.: 0.2904 sf(s)/Unit Total : 1.4522 sf(s)
6061-T6 .050 Sheet
(M6061T6S050)
Batch: M17347

SAD 07/02/24 (5)

| | | |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET
Cut as per Dwg D3484

SAD 07/02/24 (5)

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/02/24 (5)

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

J-F 07/02/24 (5)

| | | |
|-----|-------------|-------------------------------|
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr SAD 07/02/25 (5)
2-Roll as per Dwg D3484 ml 07/03/12

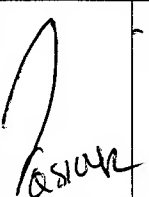
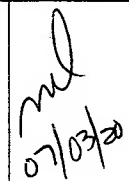

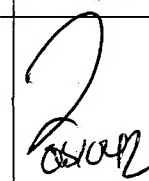

x3

PTO

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/04/11
QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|----------|------|--|--|---------------------------------|--|---|--|---|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 07/03/12 | 5 | Bend To much Two part D 3484-5. Did not able to do perfect nice job. (over bent) |  | destroy |  07/03/20 |  07/03/20 |  05/04/12 |  07/03/20 |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Monday, 2/19/2007 3:27:09 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TAIL LIGHT FAIRING

Job Number: 30774

Part Number: D34845

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/03/20

3

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/04/10

3

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/04/11

Job Completion



07/04/11

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

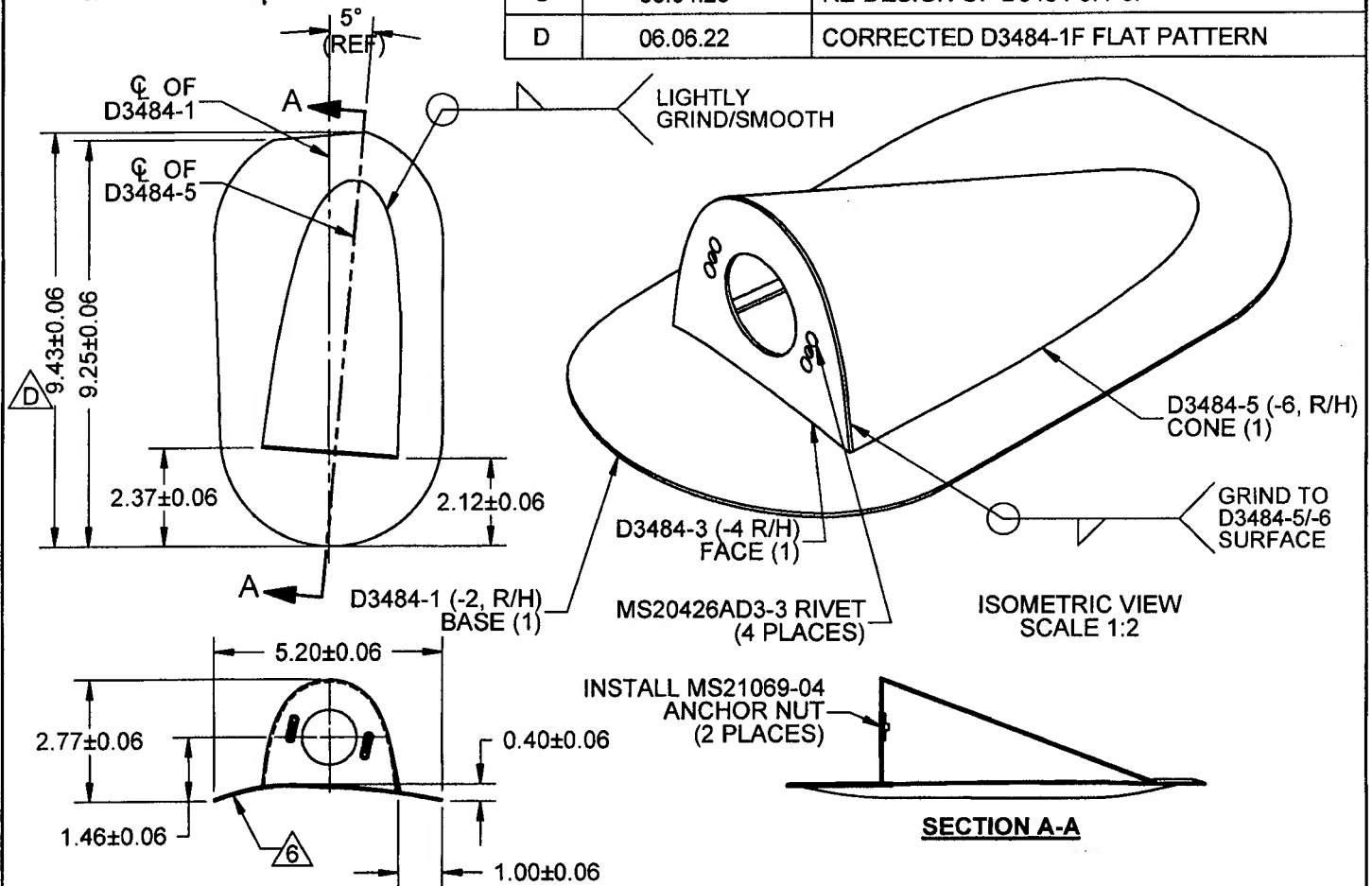
NOTE: Date & initial all entries

DART

| | | | |
|-------------------------|------------------------------------|--|------------------------|
| DESIGN | DRAWN BY | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | APPROVED | DRAWING NO. D3484 | REV. D SHEET 1 OF 4 |
| DATE 06.06.22 | TITLE TAIL LIGHT FAIRING | SCALE 1:4 | |
| A | 05.11.29 | NEW ISSUE | |
| B | 06.02.21 | RE-DESIGN | |
| C | 06.04.20 | RE-DESIGN OF D3484-3F/-5F | |
| D | 06.06.22 | CORRECTED D3484-1F FLAT PATTERN | |

RELEASED

06.08.17

**D3484-041 TAIL LIGHT FAIRING, L/H (SHOWN), R/H (OPPOSITE)****NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED WITH WHITE LABEL: "TCCA-PDA, DART AEROSPACE LTD., P/N D412-750-141/-142 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA06-13"

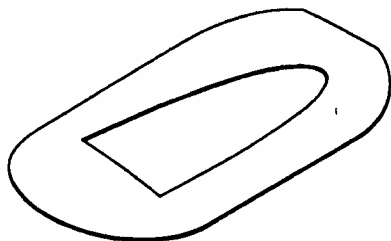
| QTY -041 | QTY -042 | P/N | DESCRIPTION |
|-------------|-------------|--------------|-----------------------------------|
| X | | D3484-041 | TAIL LIGHT FAIRING ASSEMBLY (L/H) |
| | X | D3484-042 | TAIL LIGHT FAIRING ASSEMBLY (R/H) |
| 1 | | D3484-1 | BASE (L/H) |
| | 1 | D3484-2 | BASE (R/H) |
| 1 | | D3484-3 | FACE (L/H) |
| | 1 | D3484-4 | FACE (R/H) |
| 1 | | D3484-5 | CONE (L/H) |
| | 1 | D3484-6 | CONE (R/H) |
| 4 | 4 | MS20426AD3-3 | RIVET |
| 2 | 2 | MS21069-04 | ANCHOR NUT |

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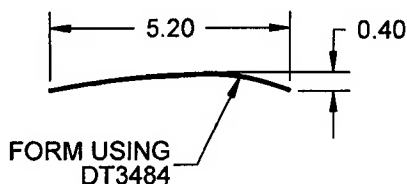
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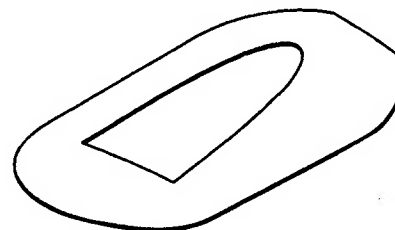
| | | | |
|-------------------------------|--------------------------------|--|------------------------|
| DESIGN <i>[Signature]</i> | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3484 | REV. D SHEET 2 OF 4 |
| DATE 06.06.22 | | TITLE TAIL LIGHT FAIRING SCALE 1:2 | |



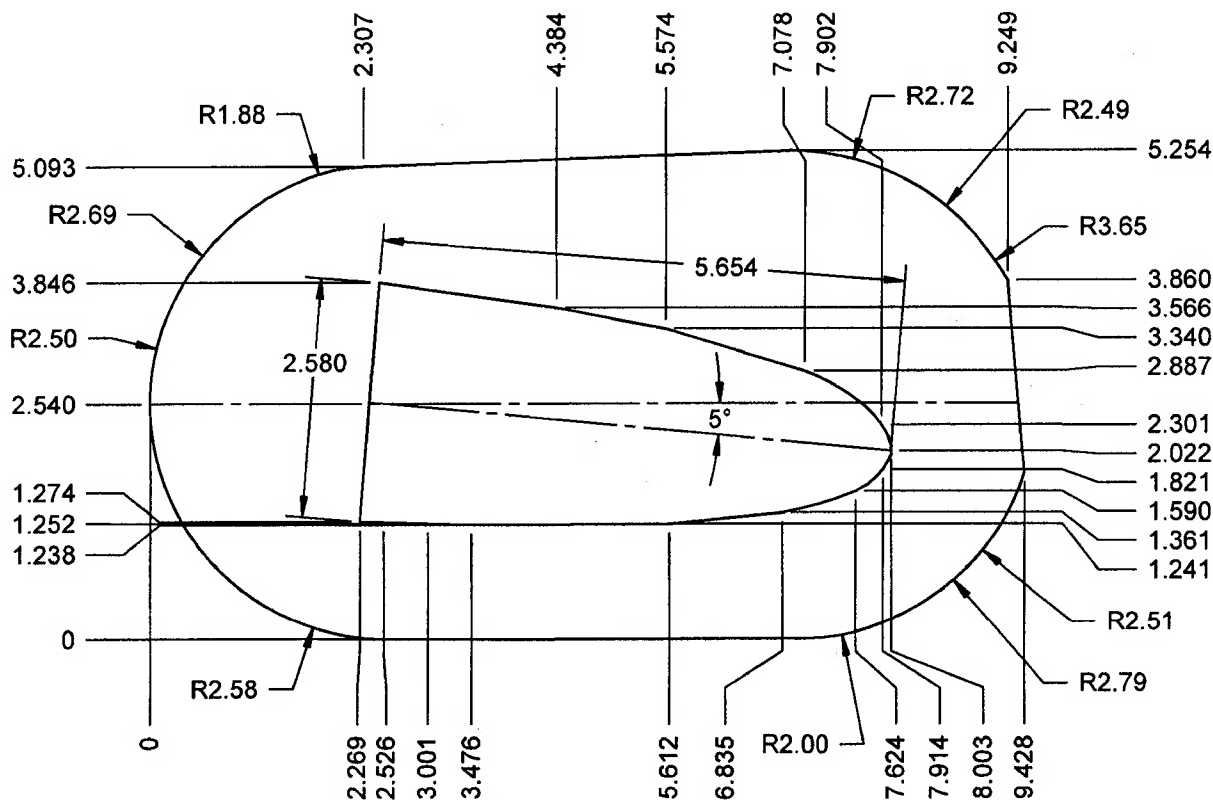
D3484-1 BASE, L/H



D3484-1 BENDING DETAIL
(D3484-2 OPPOSITE)
(MAKE FROM D3484-1F)



D3484-2 BASE, R/H



D3484-1F BASE FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.050 THICK)
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.050)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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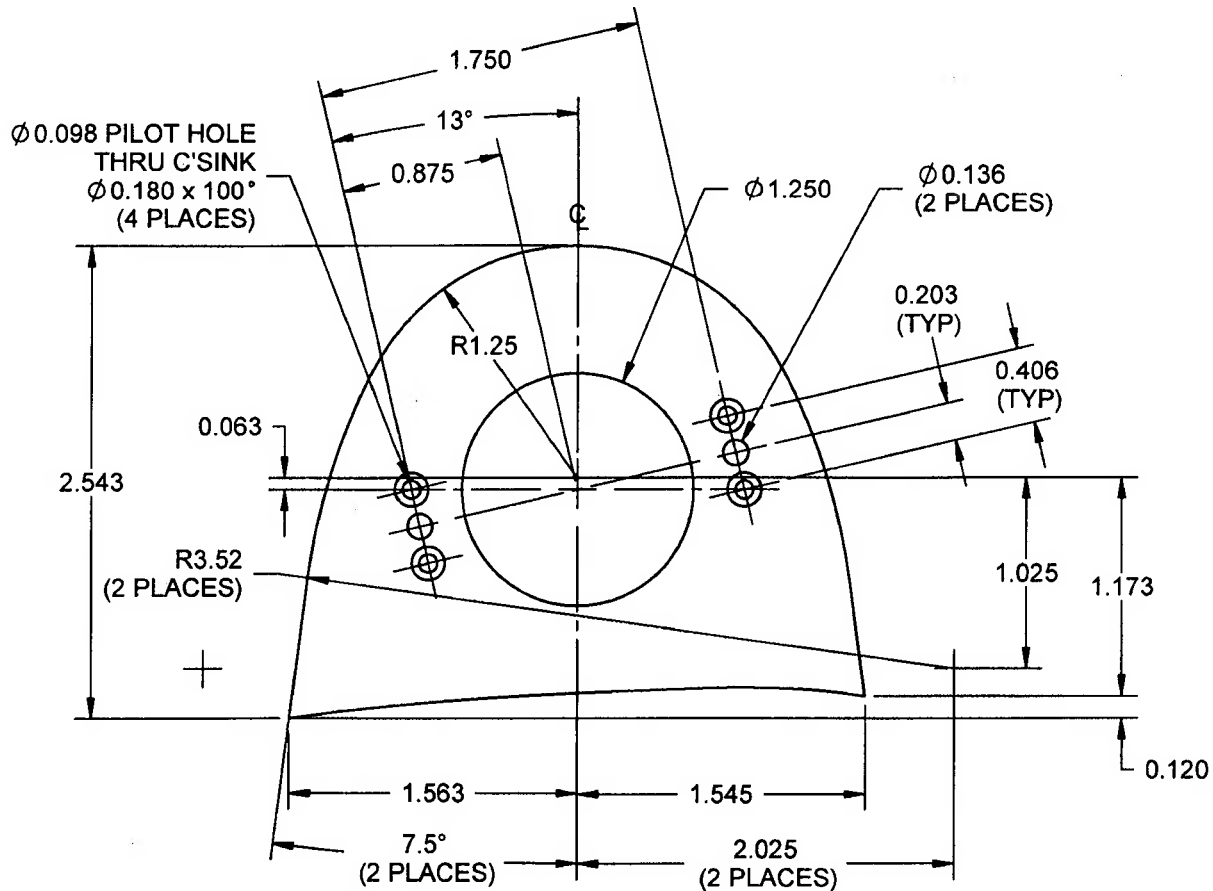
WORK ORDER
NO. 30774

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|------------------|-----------------------------|---|------------------------|
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| CHECKED # | APPROVED # | DRAWING NO. D3484 | REV. D SHEET 3 OF 4 |
| DATE 06.06.22 | TITLE TAIL LIGHT FAIRING | | SCALE 1:1 |

**RELEASED**

06.08.17 #

D3484-3 L/H FACE (-4 R/H, OPPOSITE)**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.050 THICK)
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.050)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

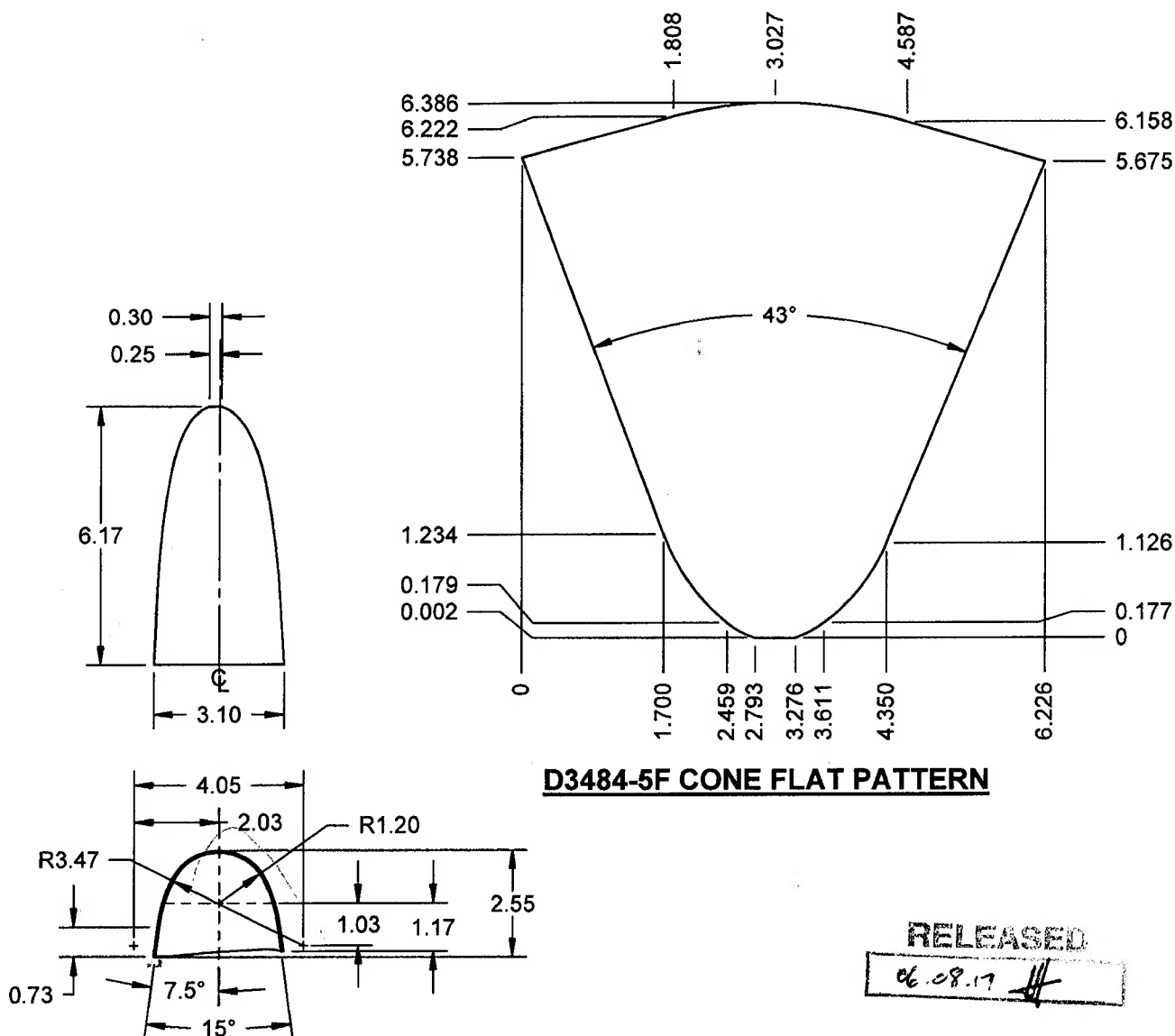
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| CHECKED # | APPROVED # | DRAWING NO. D3484 | REV. D SHEET 4 OF 4 |
| DATE 06.06.22 | | TITLE TAIL LIGHT FAIRING | SCALE 1:4 |



NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.050 THICK)
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.050)
- 2) FINISH: NONE
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- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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| | | | |
|------------------------------------|--|--------------|---------|
| DART AEROSPACE LTD | | Work Order: | 30774 |
| Description: <i>Cone LH</i> | | Part Number: | D3484-5 |
| Inspection Dwg: Rev: <i>D</i> | | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

X

First Article

X

Prototype

[illegible]

| | |
|--------------|----------|
| Measured by: | SAM |
| Date: | 07/02/24 |

| | |
|-------------|----------|
| Audited by: | J.F. |
| Date: | 07/02/24 |

| | |
|---------------------|-----|
| Prototype Approval: | N/A |
| Date: | |

| | | | | |
|-----|------|-----------|------------|----------|
| Rev | Date | Change | Revised by | Approved |
| A | | New Issue | KJ/JLM | |